

**Work Order ID 62830**

Friday, October 08, 2010 12:49:05 PM



Page 1

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Stop



Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/10/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4148	B	

100



Waterjet

FLOW CNC Waterjet

364, 175

Memo

0.00

B10-10-18

Cut as per dwg D4148

Prog Rev: B

Dwg Rev: B

Deburr as required

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B10-10-18

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC8- Inspect parts - second check

0.00

4

QC

Memo 74-03

0.00

Quality Control

150



Identify as per dwg &amp; Stock Location: B3

0.00

Packaging

Memo

0.00

Packaging

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

mf

10-10-27

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Friday, October 08, 2010 12:49:09 PM

Page 1

Work Order ID: 62830



Parent Item: D4148-1



Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	57.2523	0.3607	1.518737		 B10-10-18	

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	57.2523	
114799	57.2523	114799

(4)

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DART AEROSPACE LTD	Work Order:	(283)
Description: Fwd Crosstube Lug Plate	Part Number:	D4148-1
Inspection Dwg: D4148	Rev: A	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

Measured by:	<u>BS</u>	Audited by:	<u>/</u>	Preliminary Approval:	N/A
Date:	<u>10-10-19</u>	Date:	<u>/10/19</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	

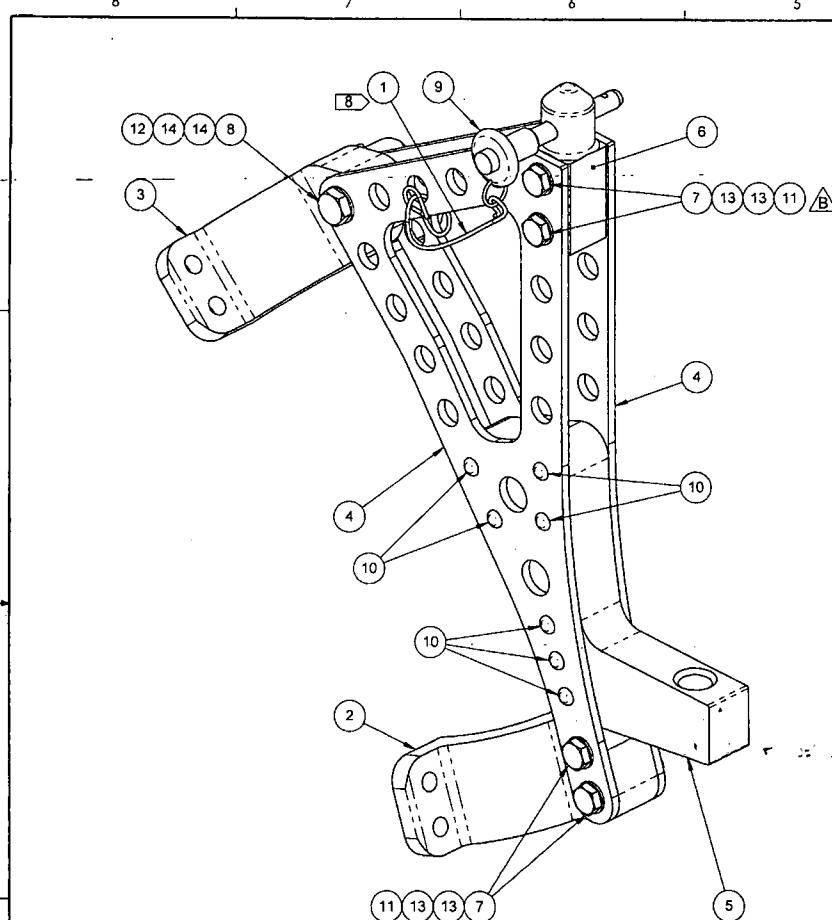
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**D4148-041 FWD X-TUBE LUG ASSY**

**A NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.47 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	7	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

SHOP COPY  
RELEASER  
ENCLOSURE COPY  
UNCONTAMINATED COPY  
SUBJECT TO APPROVAL  
WITHDRAWN  
WORK CENTER  
NO. 12830-  
PF 10108

**RELEASED**  
2010-07-16  
VMP

B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M120 (ZN D3-1 & B7-2); D0.191 2 PL REPLACES Q2.01 PL. D0.191 2 PL WAS 29 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D4148	SHEET 1 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	FWD X-TUBE LUG ASSY NTS	
DE APPR.	<i>[Signature]</i>	DATE 10.07.05	

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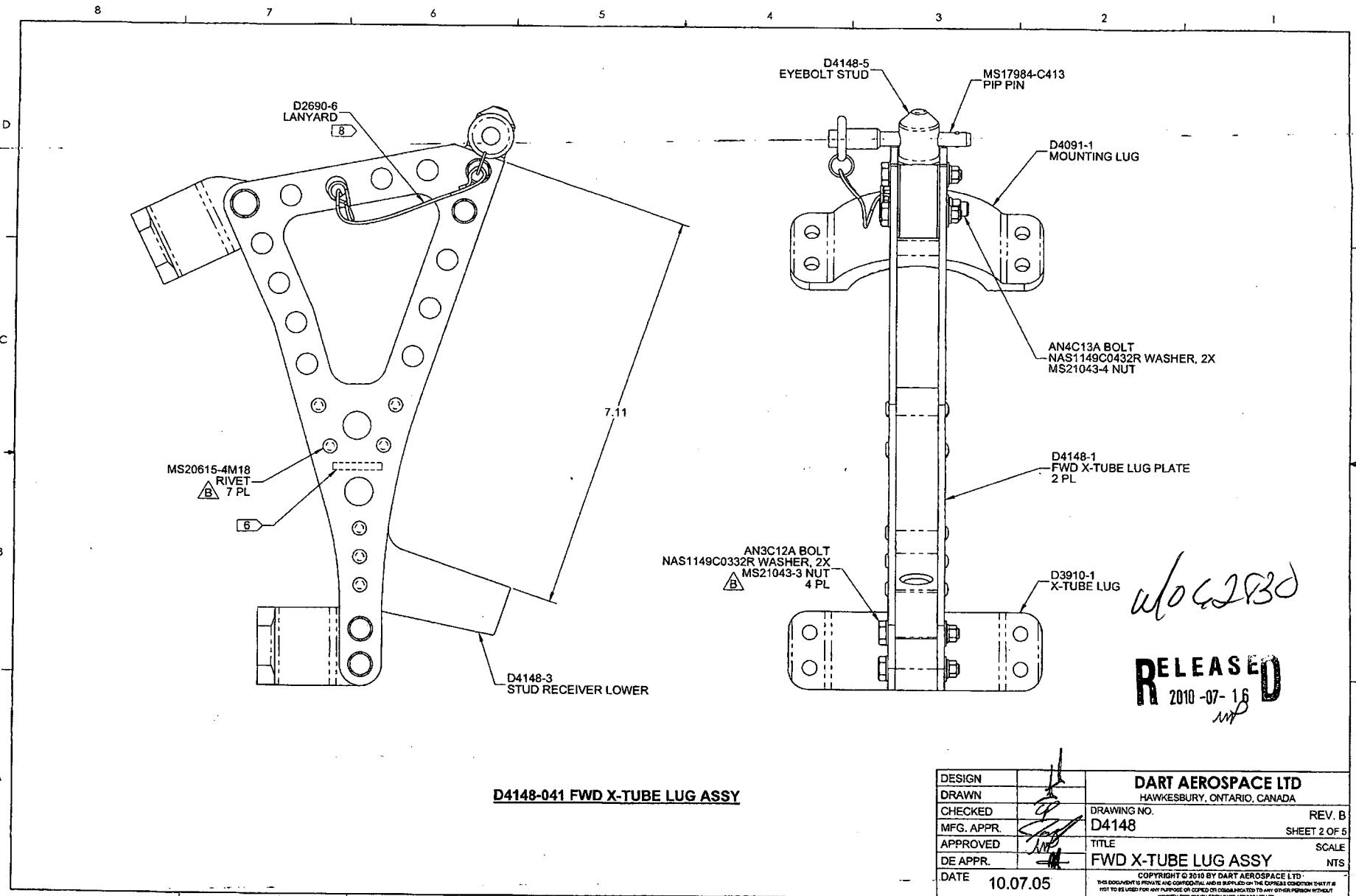
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DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B D4148	
APPROVED		SHEET 2 OF 5	
DE APPR.		TITLE	
DATE	10.07.05	SCALE NTS	

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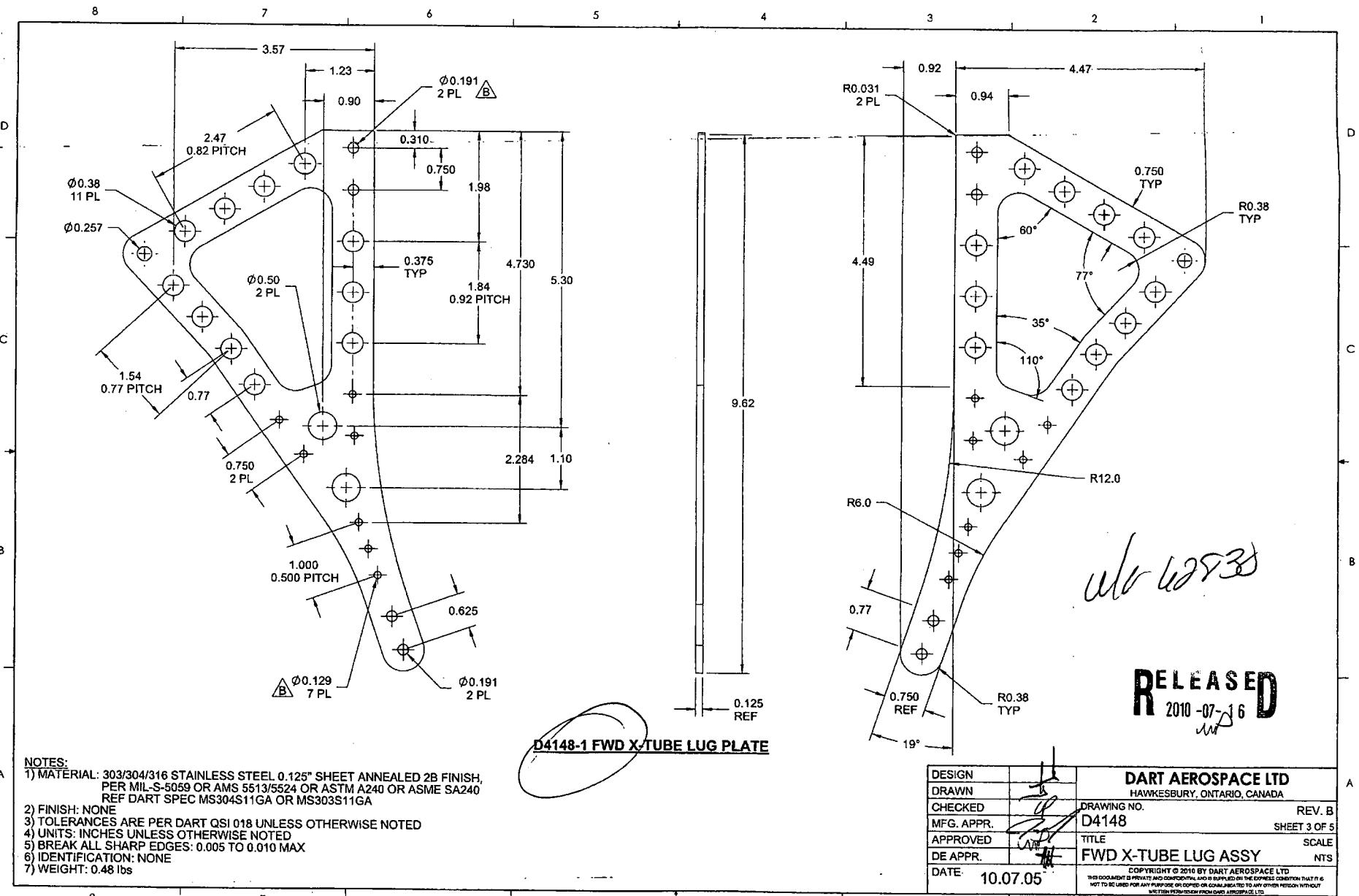
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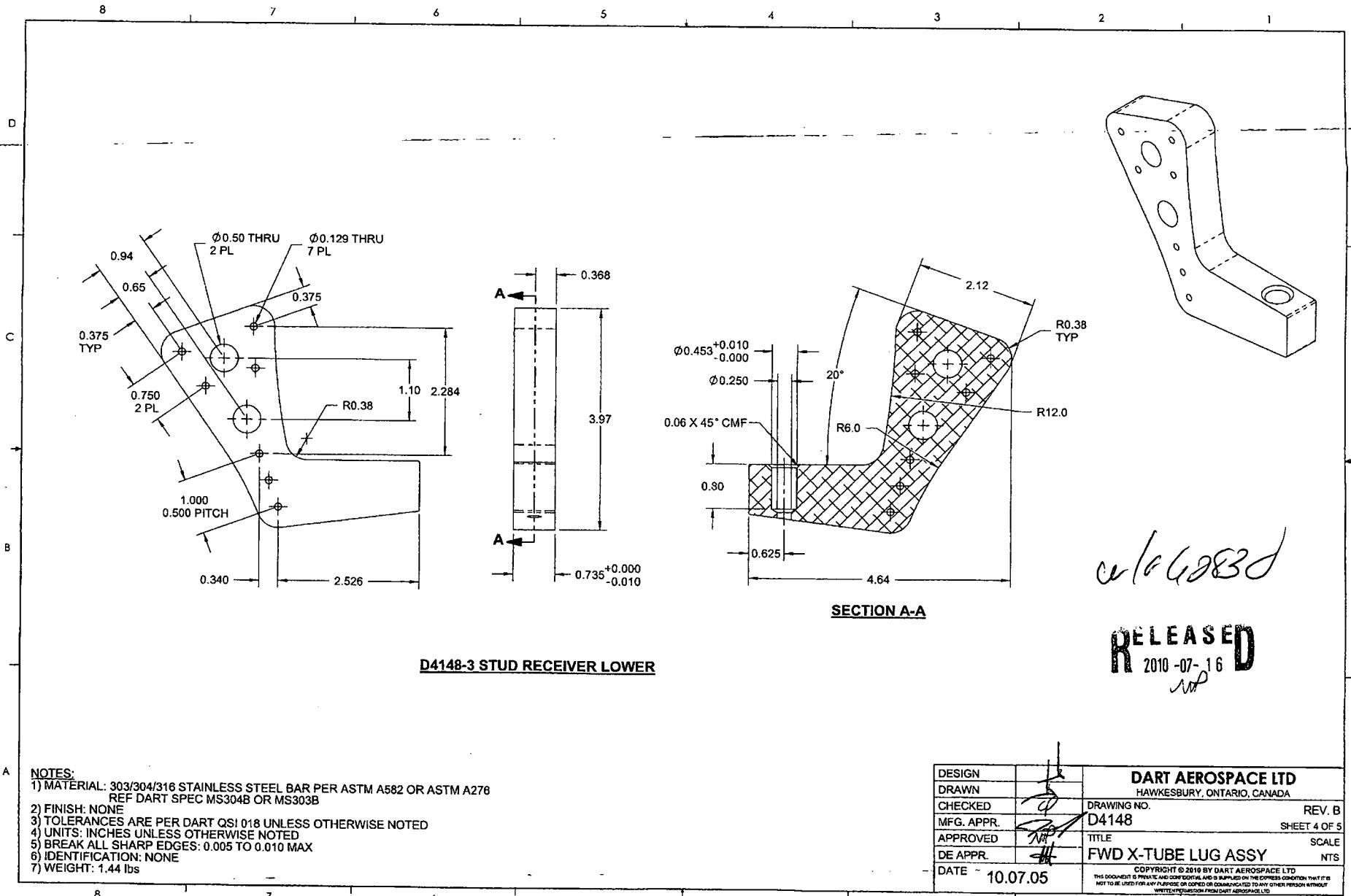
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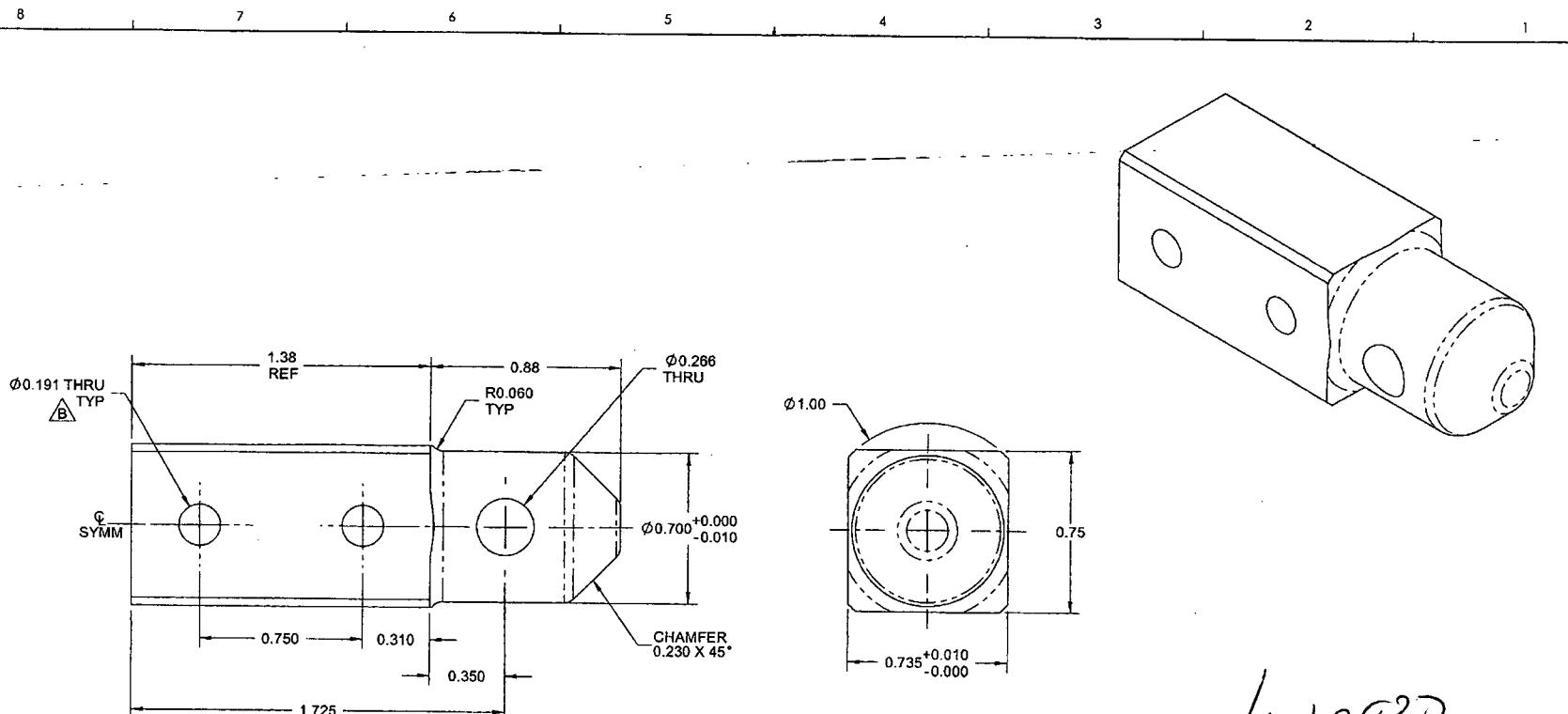
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D4148-5 EYEBOLT STUD

WB 6283D

RELEASED  
2010-07-16  
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN	A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	B	DRAWING NO. D4148
CHECKED	C	REV. B SHEET 5 OF 5
MFG. APPR.	D	TITLE FWD X-TUBE LUG ASSY
APPROVED	E	SCALE NTS
DE APPR.	F	DATE 10.07.05

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